

Work Order ID 69514

Wednesday, May 11, 2011 2:21:12 PM



Page 1

Item ID: D2150

Accept



Setup Start



Revision ID:

Stop



Item Name: Packer Doubler, Hinge

Start Date: 5/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: ASAP Date: 11-05-11 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2150

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2150 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Debur if necessary

2024.040

B11-5-12

39

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/12

count
x39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Debur

n/a

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

39 BL 11-5-12

150

0.00



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*3:50**4:20**325°F**M-f 39 11/05/12**M116964*

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Revision ID:

Stop



Item Name: Packer Doubler, Hinge

Start Date: 5/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

39 0 11/5/13

170



Packaging

Packaging

Identify as per dwg & Stock Location: 6

0.00

Memo

0.00

11/5/13 39

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/14

11-05-14
39

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 2:21:19 PM

Page 1

Work Order ID: 69514



Parent Item: D2150

Parent Item Name: Packer Doubler, Hinge

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ C ☐ 00.11.27 ☐ Re-format (mpp 2101) ☐ EC ☐
IPP Rev:D 06-08-23 Now on Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

48.9000

0.025

0.789474

1.



B 11-5-12

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

48.9

112291

0.5

112331

0.7

113162

47.7

113162

39

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Dart Aerospace Ltd

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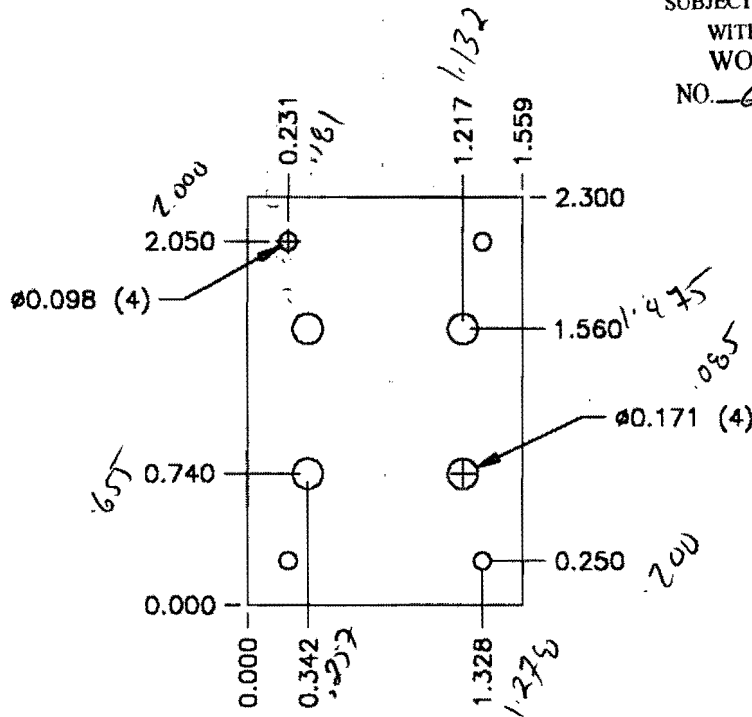


DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2150	REV. A SHEET 1 OF 1
DATE 95:05:01	TITLE PACKER		SCALE 1:1

RELEASED
96/06/13 BW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69519

P111-05-4



MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

W/O:		WORK ORDER CHANGES					
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